

Work Order ID 60422

July 7, 2010 11:26:48 AM

Page 1

Item ID: 41232-200-001-002

Accept

Setup Start

Revision ID:

Stop

Item Name: Step Actuator RH Ass'y

Start Date: 7/07/10 Start Qty: 1.00

Cust Item ID:

Required Date: 7/08/10 Req'd Qty: 1.00

Customer:

Reference:

Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

41232-200-001

Rev IR

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1- Assemble as per Dwg 41232-200-001 12-Torque as per Dwg 41232-200-001

SD 10/07/07

①

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

SD 10/07/07

xl
RH

120

Identify as per dwg & Stock Location: 36 ✓

0.00



Packaging

Memo

0.00

Packaging

10.7.7.8

Work Order ID 60422

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Item ID: 41232-200-001-002

Revision ID:

Item Name: Step Actuator RH Ass'y

Start Date: 7/07/10 Start Qty: 1.00

Required Date: 7/08/10 Req'd Qty: 1.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Sequence ID/
Work Center ID

130



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Memo

Set Up/
Run Hours

0.00

0.00

Accept



Cust Item ID:

Customer:

Date:

Date:

Setup Start

Stop

Run Start

Stop

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

1007 ST

YME
10-7-7.

Picklist Print

July 7, 2010 11:26:43 AM

Page 1 / 1

Work Order ID: 60422

Parent Item: 41232-200-001-002

Parent Item Name: Step Actuator RH Ass'y

Start Date: 7/07/10

Start Qty: 1.00

Required Date: 7/08/10

Required Qty: 1.00

Comments: IPP Rev:A New Issue 07-02-28 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|

| | | | | | | | | | | |
|-------------------|--|--------------|----|--|--|-----|------|--------|---|---|
| 41232-200-002-001 | | Manufactured | No | | | 100 | Each | 1.0000 | 1 | 1 |
|-------------------|--|--------------|----|--|--|-----|------|--------|---|---|



tube

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
|----------|---------|----------|

ST364

1

43303

1

| | | | | | | | | | | |
|-------------------|--|--------------|----|--|--|-----|------|---------|---|---|
| 41232-200-002-003 | | Manufactured | No | | | 100 | Each | 17.0000 | 1 | 1 |
|-------------------|--|--------------|----|--|--|-----|------|---------|---|---|



latch

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
|----------|---------|----------|

ST364

17

43304

9

44346

8

| | | | | | | | | | | |
|-------------------|--|--------------|----|--|--|-----|------|----------|---|---|
| 41232-200-003-001 | | Manufactured | No | | | 100 | Each | 102.0000 | 1 | 1 |
|-------------------|--|--------------|----|--|--|-----|------|----------|---|---|



Spring (Step Actuator)

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
|----------|---------|----------|

ST365

102

54173

102

| | | | | | | | | | | |
|-------------------|--|--------------|----|--|--|-----|------|---------|---|---|
| 41232-200-005-003 | | Manufactured | No | | | 100 | Each | 12.0000 | 2 | 2 |
|-------------------|--|--------------|----|--|--|-----|------|---------|---|---|



Spacer (Step Actuator)

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
|----------|---------|----------|

ST365

12

43732

12

41232-200-002-005 M 10.07.07

43305

①

SB 10/07/07

SB 10/07/07

SB 10/07/07

SB 10/07/07

SB 10/07/07

Picklist Print

July 7, 2010 11:26:44 AM

Work Order ID: 60422

Parent Item: 41232-200-001-002

Parent Item Name: Step Actuator RH Ass'y

41232-200-008-001



Decal

AN315-4R



Nut

Purchased

No

100

Each

0.0000

1

Location

Loc Qty

Loc Code

ST324

73

17566

73

100

Each

45.0000

1

AN3-22A

Purchased

No



Bolt

Location

Loc Qty

Loc Code

ST352

45

110998

30

111072

15

100

Each

8.0000

1

AN842-4D

Purchased

No



Elbow

Location

Loc Qty

Loc Code

ST334

8

108077

6

110139

2

100

Each

0.0000

2

2

AN960JD10

NAS1149D0363J

Purchased

No



Washer

1114884

Start Date: 7/07/10

Start Qty: 1.00

Required Date: 7/08/10

Required Qty: 1.00

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SP 10/07/07 ①

SP 10/07/07 ①

SP 10/07/07 ①

SP 10/07/07 ①

July 7, 2010 11:26:44 AM

Shop Packet Print

Page 2

Picklist Print

July 7, 2010 11:26:44 AM

Work Order ID: 60422

Parent Item: 41232-200-001-002

Parent Item Name: Step Actuator RH Ass'y



Start Date: 7/07/10

Start Qty: 1.00

Required Date: 7/08/10

Required Qty: 1.00

X

AN960JD416 NAS1149D0463J Purchased No



Washer

Location

ST351
108827

Loc Qty

16
16
Each

Loc Code

4115000

0.0000

B

60410

409.0000

(2)

SB 10/07/07 (1)

X

D3975-042 Manufactured No



Gas Cylinder Assembly, RH

MS16996-23



cap screw

Location

ST314
103934
112492

Loc Qty

409
9
400
Each

Loc Code

10.0000

(1)

SB 10/07/07 (1)

MS20822-4 Purchased No



elbow

Location

ST299
110363

Loc Qty

10
10

Loc Code

4107292

2,833.000

(1)

SB 10/07/07 (1)

MS21042L3 Purchased No



Nut

Location

ST300
114523
114718
114784

Loc Qty

2833
351
482
2000

Loc Code

(1)

SB 10/07/07 (1)

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Shop Packet Print

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Picklist Print

July 7, 2010 11:26:44 AM

Work Order ID: 60422

Parent Item: 41232-200-001-002

Parent Item Name: Step Actuator RH Ass'y

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Start Date: 7/07/10

Start Qty: 1.00

Required Date: 7/08/10

Required Qty: 1.00

S-1455

Purchased

No

100

Each

120.0000

1

1



spring-step actuator (replaces 71459)



Location

Loc Qty

Loc Code

ST396

120

111342

120

n 16054

SB 10/07/07 ①

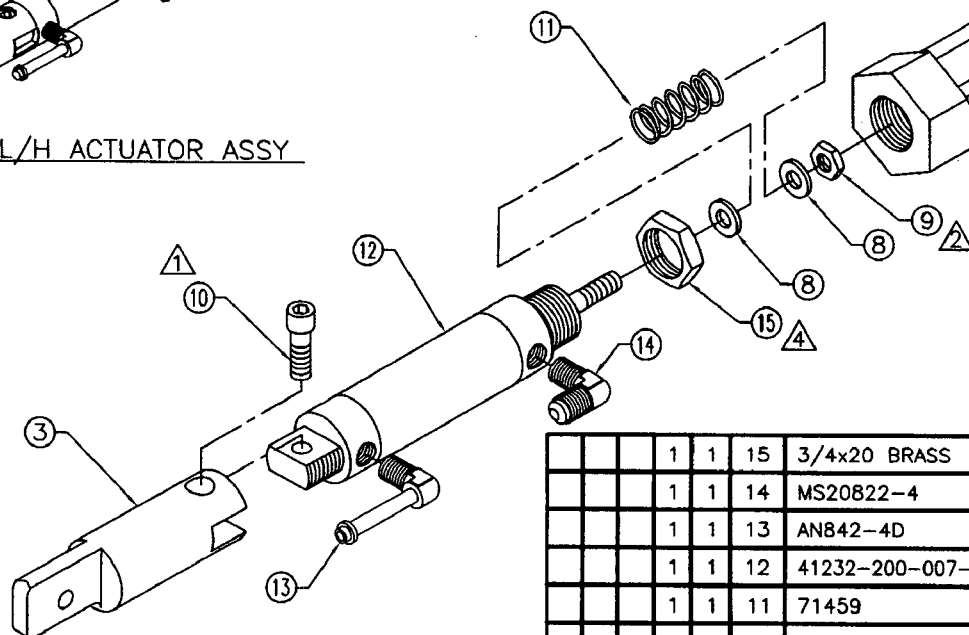
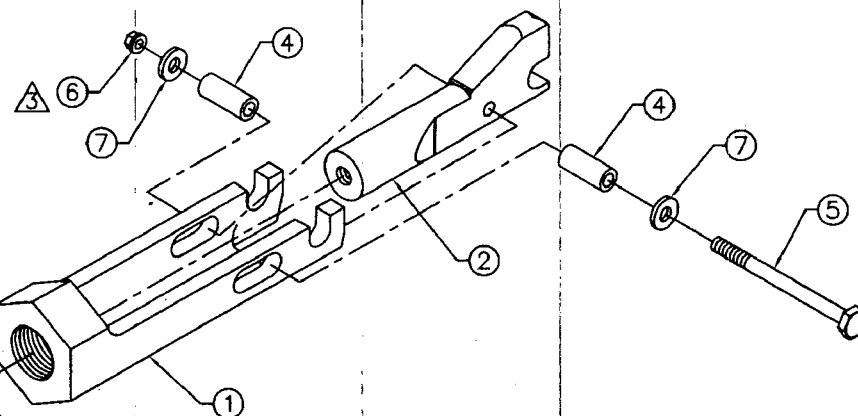
SB 10/07/07 ①

July 7, 2010 11:26:44 AM

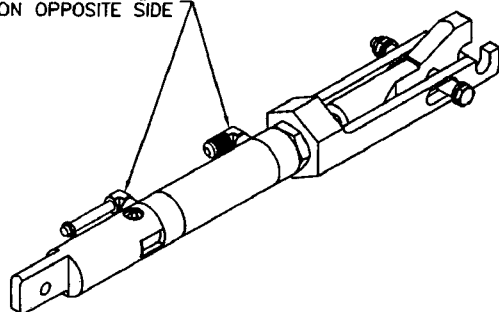
Shop Packet Print

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-001 L/H ACTUATOR ASSY



INSTALL ITEM #12
ON OPPOSITE SIDE



-002 R/H ACTUATOR ASSY

-  TORQUE 80-100 IN.-LB.
 TORQUE 20-25 IN.-LB.
 TORQUE 50-75 IN.-LB.
 TORQUE 50-75 IN.-LB.

NOTES:

| | | | | | | | | | | | | |
|--|--|--|------|------|---------|-------------------|-------------------|------------|----------|-----------|------|--|
| | | | 1 | 1 | 15 | 3/4x20 BRASS | CYLINDER NUT | | | | | |
| | | | 1 | 1 | 14 | MS20822-4 | ELBOW | | | | | |
| | | | 1 | 1 | 13 | AN842-4D | ELBOW | | | | | |
| | | | 1 | 1 | 12 | 41232-200-007-001 | CYLINDER | | | | | |
| | | | 1 | 1 | 11 | 71459 | SPRING | | | | | |
| | | | 1 | 1 | 10 | MS16996-23 | CAP SCREW | | | | | |
| | | | 1 | 1 | 9 | AN315-4R | NUT | | | | | |
| | | | 2 | 2 | 8 | AN960JD416 | WASHER | | | | | |
| | | | 2 | 2 | 7 | AN960JD10 | WASHER | | | | | |
| | | | 1 | 1 | 6 | MS21042-L3 | NUT | | | | | |
| | | | 1 | 1 | 5 | AN3-22A | BOLT | | | | | |
| | | | 2 | 2 | 4 | 41232-200-005-003 | SPACER ✓ | | | | | |
| | | | 1 | 1 | 3 | 41232-200-002-005 | PIVOT ARM | | | | | |
| | | | 1 | 1 | 2 | 41232-200-002-003 | LATCH ✓ | | | | | |
| | | | 1 | 1 | 1 | 41232-200-002-001 | TUBE ✓ | | | | | |
| | | | / | | | -002 | R/H ACTUATOR ASSY | | | | | |
| | | | / | | | -001 | L/H ACTUATOR ASSY | | | | | |
| | | | -002 | -001 | FND NO. | PART NO. | NAME | STOCK SIZE | MATERIAL | MATL SPEC | ZONE | |

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| | | |
|-----|---|---------------|
| 002 | 1 | 41232-000-001 |
| 001 | | |

| | | |
|------|-----------|---------------|
| DATE | REC'D PER | NEXT ASSEMBLY |
|------|-----------|---------------|

UNLESS
OTHERWISE
SPECIFIED
X.±.1
XX.±.03
XXX.±.010
ANGLES
±.1/2

| |
|----------------|
| DRAFTSMAN |
| CHECK |
| STRESS |
| PROJ. ENGR. |
| HEAT TREAT |
| FINISH |

| |
|-----------|
| D. NELSON |
| D. MURPHY |
| |
| |
| |
| E. |

| | |
|--|---------|
| | 5/20/02 |
| | 5/20/02 |
| | |
| | |

| | |
|-----------|----|
| TITLE | ST |
| DWG. SIZE | |

STEP A

C

| | |
|----------|--|
| SCALE | |
| DWG. NO. | |
| 41232 | |

FOR A
NONE
2-200-0

| | |
|-----|---------|
| SSY | |
| E | |
| 001 | REV. 1E |

Era Aviation, Inc.

41232-200-001

REV. 1/81